

Work Order ID 122210

D 2850-1

122210

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July-10-14 11:29:22 AM

B 122210

Item ID: D2850-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: End Bracket

Start Date: 7/10/14

Start Qty: 20.00

20

Cust Item ID:

Required Date: 7/10/14

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 14-07-10

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2850

Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 3.8"

20

0

MH

14/07/19

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per Folio D2850-1
Deburr and Tumble

20

1

MH

14/07/20

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

20

1

MH

14/07/20

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Item ID: D2850-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: End Bracket
 Start Date: 7/10/14 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 7/10/14 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						20	0		DAS 44 9-89 14/07/20
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>WMA003</u>	0.00							
140						20	0		DAS 19 9-89 14-07-22
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									14/7/23
QC	Memo	0.00							
Quality Control									

4.7.22

Picklist Print

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Work Order ID: 122210

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Parent Item: D2850-1

D2850-1

Parent Item Name: End Bracket

Start Date: 7/10/14

Required Date: 7/10/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP B98.12.07Changed folioDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.500X01.50 0		Purchased		No			f	11.8590		7			

M6061T6B2 500X01 500

**

6061-T6 Bar 2.50 x 1.50

Location

Loc Qty

Loc Code

MAT

11.859

m128054

11.859

*124681

m126724

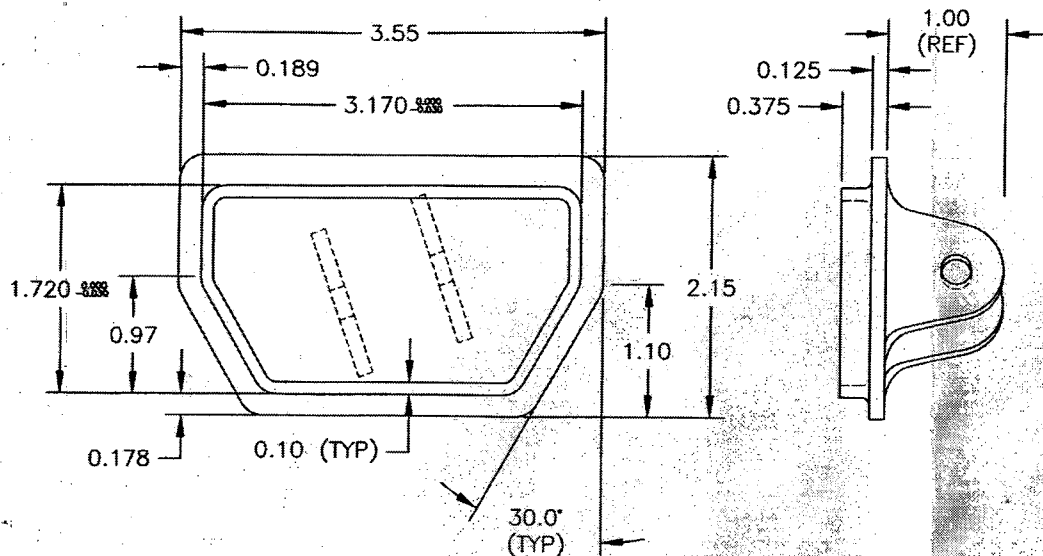
m128980

2
1.35
3.325

MH
14/02/16

6.675

* Could not pull
Material.



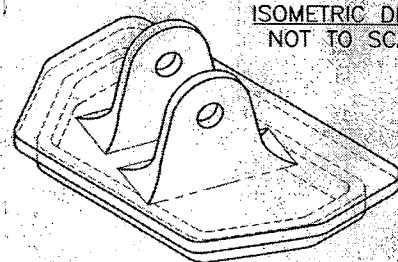
D2850-1 (SHOWN)
D2850-2 (OPPOSITE)

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

FINISH: NONE

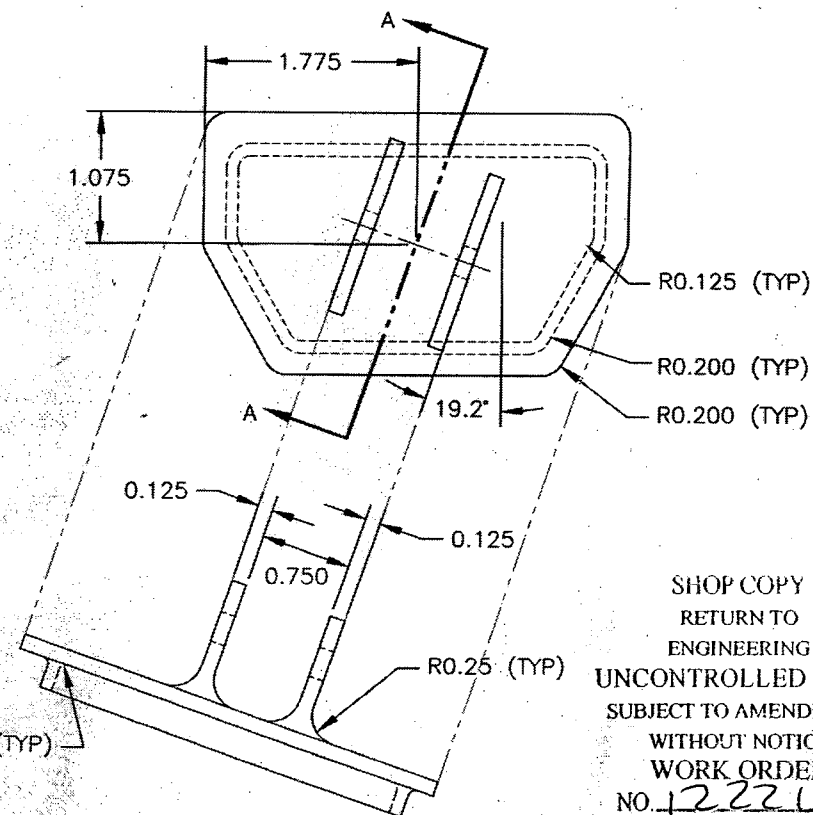
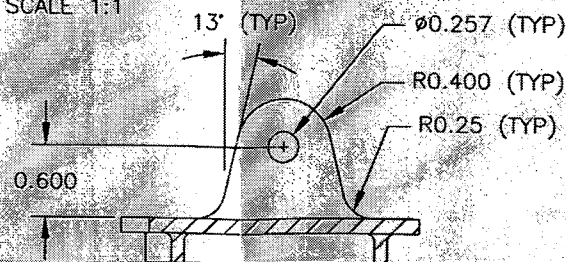
BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



ISOMETRIC DETAIL
NOT TO SCALE

SECTION A-A
SCALE 1:1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122210

ML51407
10

RELEASED
98.11.25 KE

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN CP	DRAWN BY CP	DART DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA	
CHECKED KE	APPROVED #	DRAWING NO. D2850	REV. A SHEET 1 OF 1
DATE 98.11.10	TITLE HIGH FLOAT STEP END BRACKET	SCALE 1:1	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>122210</u> Part No. <u>D2850-1</u> NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design <input type="checkbox"/> Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Pre <input type="checkbox"/> Material <input type="checkbox"/> Operator <input type="checkbox"/> Offset/Setup <input checked="" type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Transport <input type="checkbox"/> Unapproved <input type="checkbox"/>	14/07/19	110	1	part was not tight enough in vice. moved when being machined. R.L. vice set up was not reversed correctly/Operator Error.	DAS 16 9-89 QJ2042 14/07/21	Scrap and Destroy replace with B# 128054	P/H 14/07/20	DAS 44 9-89 14/07/20	DAS 16 9-89 QJ2042 14/07/21

FAULT CATEGORY

Landing Gear	General
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function

<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input checked="" type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
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<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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